

Work Order ID 83123-2

83123

Page 1

April-13-12 7:31:40 AM

Item ID: D4617-7

Revision ID:

Item Name: Clamp Half

Start Date: 13/04/2012 Start Qty: 1.00 *1*

Required Date: 20/04/2012 Req'd Qty: 1.00 *1*

Reference:

Approvals: Process Plan: MCS

QC:

Date: 12/04/13

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4617

PA1

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO
FOLIO REV: 13/04
DWG REV: 13/04

DEBURR

AS AP
Split-2

12/04/13

13/04/12

30

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D4617-7

Accept

Revision ID:

Item Name: Clamp Half

Start Date: 13/04/2012 Start Qty: 1.00

1

Required Date: 20/04/2012 Req'd Qty: 1.00

1

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005.4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

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Item ID: D4617-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp Half

Stop *NS2*

Start Date: 13/04/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Q 12-4-17

03638 Apr 12-04-17

W/O:		WORK ORDER CHANGES					
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Picklist Print

April-13-12 7:37:45 AM

Page 1

Work Order ID: 83123

83123

Parent Item: D4617-7

D4617-7

Parent Item Name: Clamp Half

Start Date: 13/04/2012

Required Date: 20/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV: A NEW ISSUE 12-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.625X01.500		Purchased	No				f	18.5600		0.166316			

M6061T6B0 625X01 500

**

6061-T6 Bar .625 x 1.50

Location

Loc Qty

Loc Code

MAT002

18.56

115111

18.56

5.06 - 12/04/12

W/O:		WORK ORDER CHANGES					
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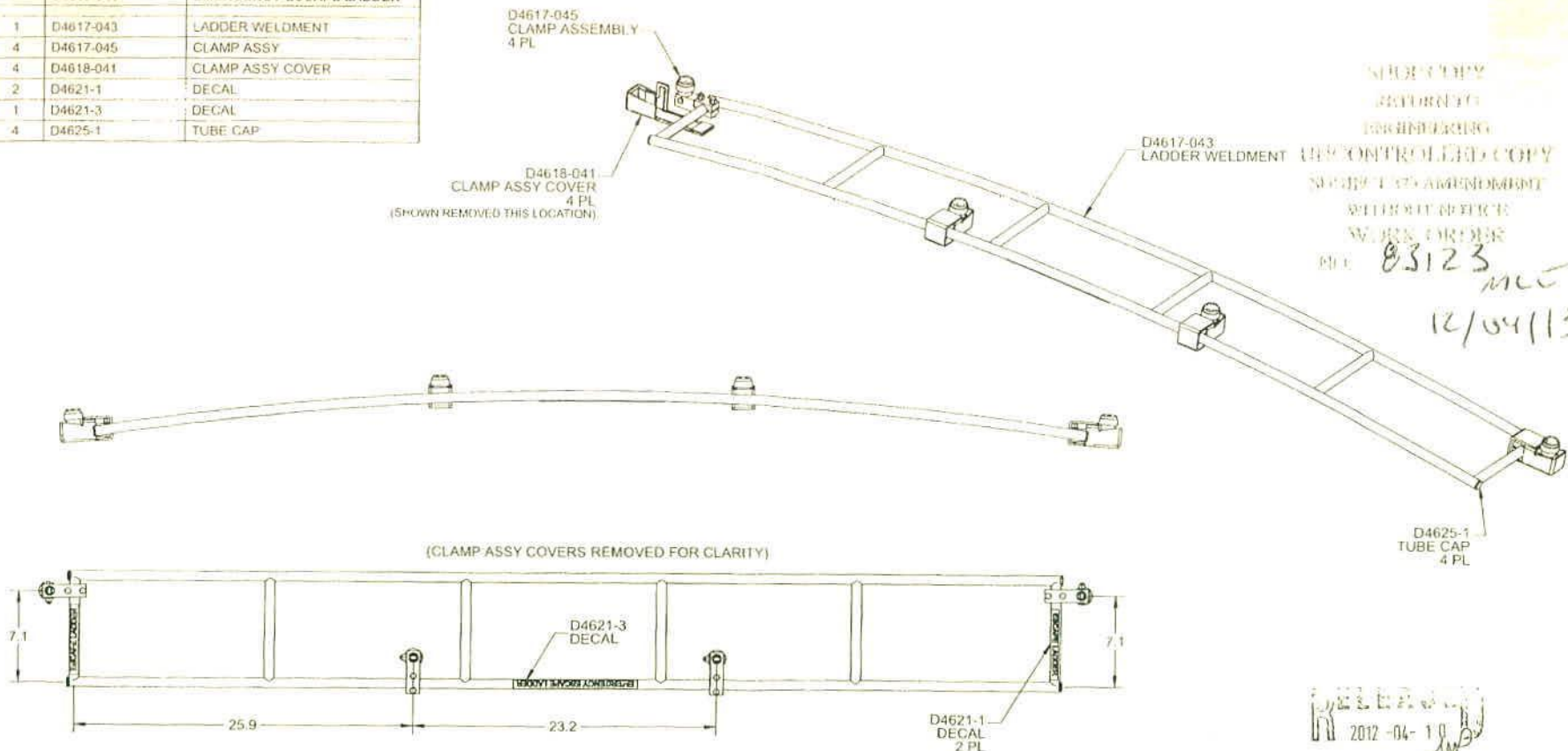
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



D4617-041 EMERGENCY ESCAPE LADDER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6 6
- 7) WEIGHT: 6.46 lbs

REV	NEW ISSUE	DESCRIPTION	RP	12.04.02
DESIGN	RP		BY	DATE
DRAWN	RP			
CHECKED	A.P.			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.04.02			

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A

D4617 SHEET 1 OF 5

TITLE SCALE

EMERGENCY ESCAPE LADDER NTS

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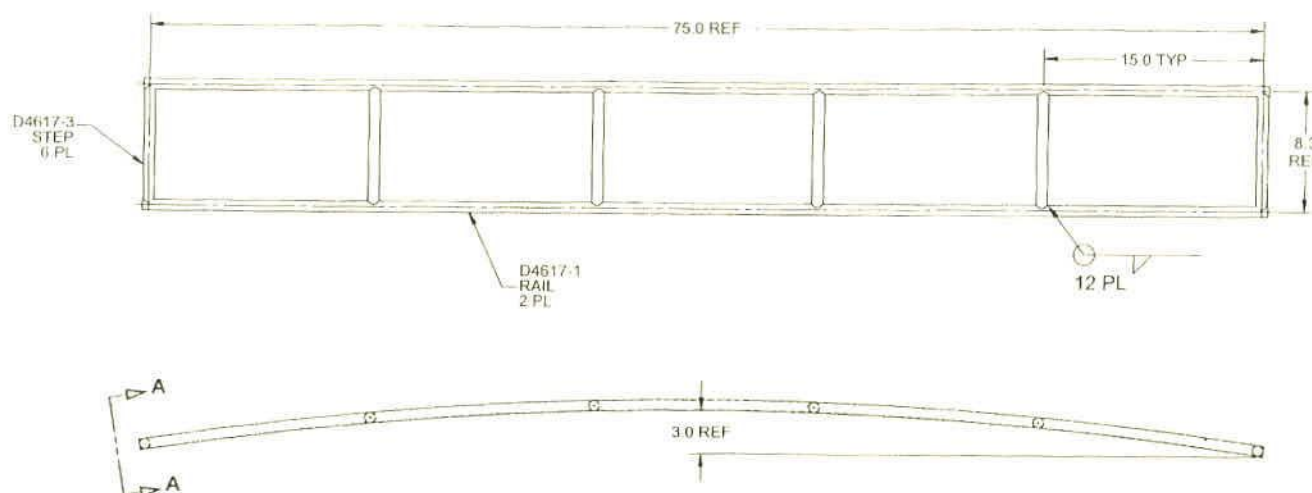
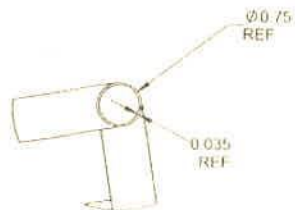
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NOTE: Date & initial all entries

03123



D4617-043 LADDER WELDMENT

RELEASED
2012-04-10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044.6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

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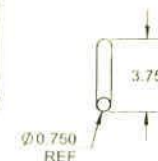
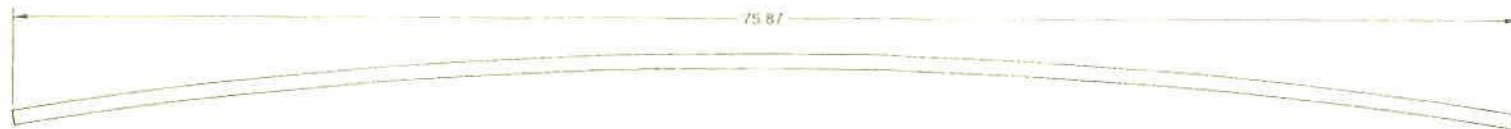
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

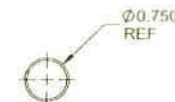
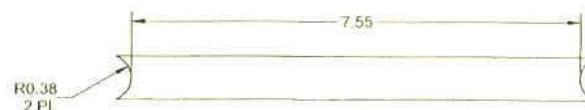
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NOTE: Date & initial all entries

03123



D4617-1 RAIL



D4617-3 STEP

NOTES

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

RELEASED
2012-04-18

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AL	DRAWING NO.	REV. A
MFG. APPR.	GP	D4617	SHEET 3 OF 5
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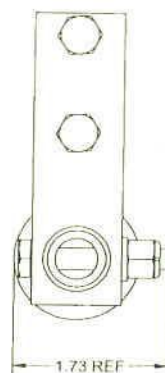
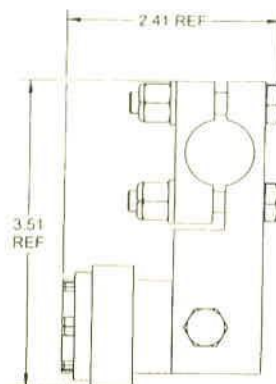
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

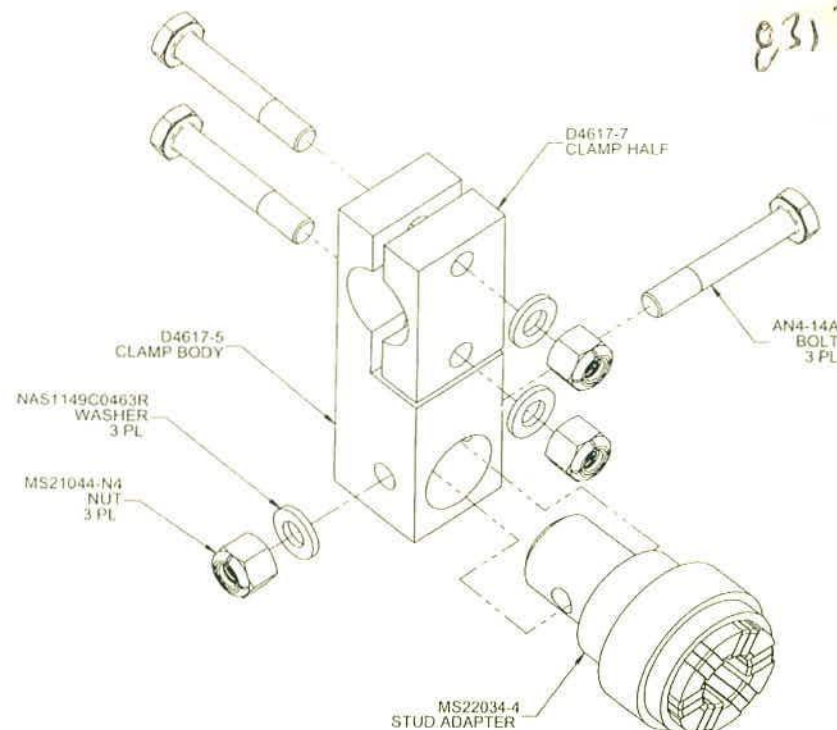
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ITEM	QTY	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	3	MS21044-N4	NUT
5	1	MS22034-4	STUD ADAPTER
6	3	NAS1149C0463R	WASHER



D4617-045 CLAMP ASSY



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 0.5 lbs

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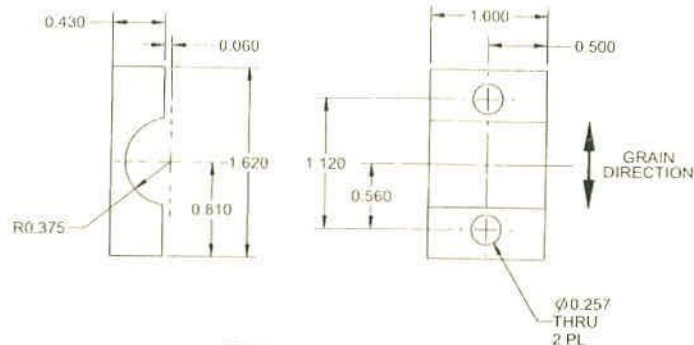
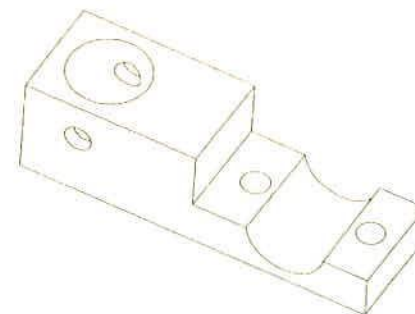
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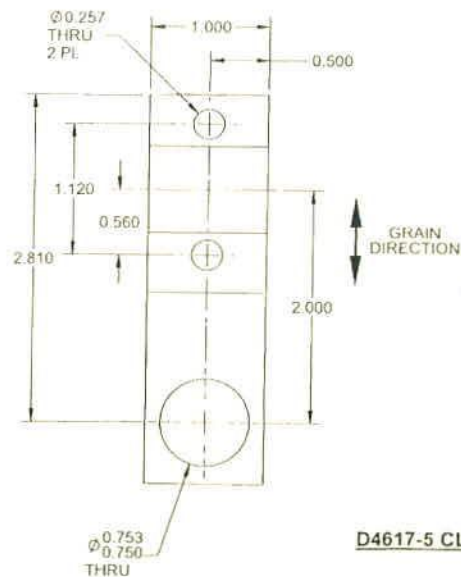
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83123



D4617-7 CLAMP HALF



D4617-5 CLAMP BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06
D4617-7: EAGLE P/N 212-110-07

RELEASE
2012-04-10

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